

Work Order ID 85038

May-31-12 3:37:55 PM

85038

Page 1

Item ID: D3898-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Floor Protector (206L)

Start Date: 31/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/06/01*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr Revision Nbr

D3898 Rev A

100

0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

[Handwritten signature]

B 12/06/18

105

0.00

105

HandThermo

Dry material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: *240*

Time IN: *4:30*

Time OUT: *7:00*

1

B 12/06/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Mav-31-12 3:37:55 PM

Page 2

Setup Start *NS1*

Stop *NS2*

Start Date: 31/05/2012 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 14/06/2012 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

0.00

Thermoform

Thermoforming Machine

Memo

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA0xxusing tool DT9501
Dwg Rev: _____
Folio Rev: _____

120

QC2- Inspect parts off machine FAI/FAIB	0.00
---	------

0.00

120

0.00

OC

Quality Control

Memo

Visually inspect part for proper formation and texture

130

QC8- Inspect parts - second check	0.00
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0.00

130

0.00

QC

Quality Control

Dart Aerospace Ltd

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12/06/18	110							

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May-31-12 3:37:55 PM

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Page 3

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00

140

HandThermo

Memo

0.00

Hand Finishing Thermoforming

I-Trim to finished dimensions as per Dwg

B 12/06/20

150

QC2- Inspect parts off machine FAI/FAIB

0.00

150

QC

Memo

0.00

Quality Control

Complete FAI document

B 12/06/20

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

S 12/06/20

(X)

W/O:		WORK ORDER CHANGES					
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Page 4

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Start Date: 31/05/2012 Start Qty: 1.00

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Cust Item ID:

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Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

170

Identify as per dwg & Stock Location: _____

0.00

170

Packaging

Memo

P/P 85031

0.00

Packaging

12/6/22 (1)

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/6/25
MW 12/06/22

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

May-31-12 3:37:59 PM

Page 1

Work Order ID: 85038

85038

Parent Item: D3898-1

D3898-1

Parent Item Name: Floor Protector (206L)

Start Date: 31/05/2012

Required Date: 14/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev.A New Issue 09/02/06 DL
Add Step 105 Dry Material 10/04/21 DL

IPP RevB

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	1,122.596	10.6	11.15789			

MI FXS 118-90318-08

Lexan Sheet

**

Location

therm

113127

Loc Qty

1122.596941

1122.59694

Loc Code

11.158

sg pt

OK
12/06/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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& initial all entries

DART AEROSPACE LTD		Work Order:	85038
Description: Floor Protector		Part Number:	D3898-1
Inspection Dwg: D3898	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: JB

Date: 12/06/18

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.50	Min	.560	✓			
1.00	Min	1.00	✓			
5.6	+0.2/-0.0	5.7	✓			
0.080	Min	.083	✓			
0.050	Min	.057	✓			

Measured by: JB

Date: 12/06/20

Audited by: OK

Date: 12/06/20

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	<u>[Signature]</u>

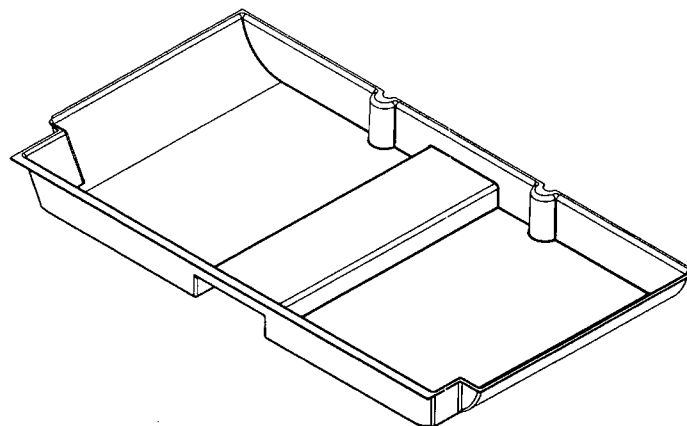
W/O:		WORK ORDER CHANGES					
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D3898-1 FLOOR PROTECTOR (206L)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 85038 MLJ
12/06/01

RELEASED
09/06/08 MLJ

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3898-1" USING VIBRATING STYLUS
- 7) WEIGHT: 5.0 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9501 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" EXCEPT AS SHOWN

A	NEW ISSUE		PH	09.02.27
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	PH			
CHECKED	PH	DRAWING NO.	REV. A	
MFG. APPR.	PH	D3898	SHEET 1 OF 2	
APPROVED	PH	TITLE	SCALE	
DE APPR.	PH	FLOOR PROTECTOR (206L)	NTS	
DATE	09.02.27		<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

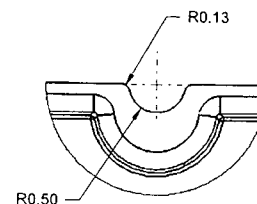
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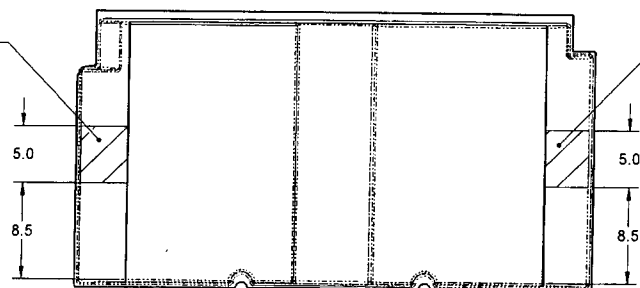
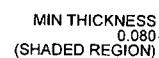
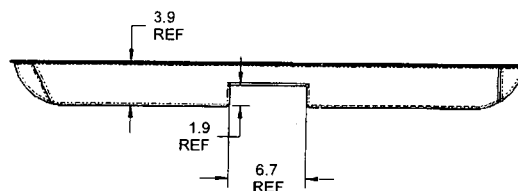
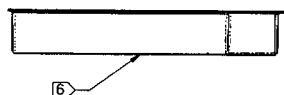
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DETAIL B D5-2
SCALE 5X
2 PL



D3898-1 FLOOR PROTECTOR (206L)

MIN THICKNESS
0.080
(SHADED REGION)

RELEASED
09/06/08

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3898 TITLE FLOOR PROTECTOR (206L) COPYRIGHT © 2009 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	REV. A	
DRAWN	PH		SHEET 2 OF 2	
CHECKED			TITLE	SCALE
MFG. APPR.			FLOOR PROTECTOR (206L)	NTS
APPROVED				
DE APPR.				
DATE	09.02.27			

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